

Work Order ID 62822

Friday, October 08, 2010 12:47:08 PM



Page 1

Item ID: D3246-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Mounting Bracket

Start Date: 10/8/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 10/15/2010 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

[Handwritten signature]

Date:

10-10-8

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3246	Rev A1

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg Dsi9279 ☒ Dwg Rev: *A1* ☐ Prog Rev: *A1* ☐ 2-
Deburr if necessary

2024 050

B10-10-12

(4)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-10-12

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S 10/10/13

(74)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



Brake NC

NC BRAKE

0.00

Memo

0.00

Debur ☐ Form as per Dwg D3246 ☐ C'sink as per Dwg D3246

Brake NC

SB 10/10/26

10/10/14

(4)

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

S 10/10/26

(74)

150



HandFinish

Chemical Conversion Coat per QS1005 4.1

0.00

Memo

0.00

Hand Finishing

BR 10/10-26

(4)

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

7/11 10/10/26

4

0

170

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

Install Nut Plates as per Dwg D3246

ES 10/10/26

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 10/10/26

7/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Page 4

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Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

Identify as per dwg & Stock Location 44

0.00



Packaging

Memo

0.00

Packaging

10/10/26

(40)

SP

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/10/27

mf

10-10-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Picklist Print

Friday, October 08, 2010 12:47:12 PM

Page 1

Work Order ID: 62822

Parent Item: D3246-041

Parent Item Name: Mounting Bracket




Start Date: 10/8/2010

Required Date: 10/15/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 06-06-22 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MS21059L3  Nut Plate		Purchased	No			110	Each	73.0000	4	16			
<div> <div>Location</div> <div>ST301</div> <div>114718</div> <div>115708</div> <div>115727</div> </div> <div> <div>Loc Qty</div> <div>73</div> <div>6</div> <div>2</div> <div>65</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
M2024T3S.050  2024-T3 .050 sheet		Purchased	No			170	sf	108.8847	0.3097	1.304			
<div> <div>Location</div> <div>MAT22</div> <div>111381</div> <div>113189</div> <div>114968</div> </div> <div> <div>Loc Qty</div> <div>108.8847</div> <div>12.49</div> <div>0.3947</div> <div>96</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> <div></div> </div>													
MS20426AD3-3  Rivet		Purchased	No			170	Each	4,419.000	8	32			
<div> <div>Location</div> <div>ST316</div> <div>19099</div> <div>7681</div> </div> <div> <div>Loc Qty</div> <div>4419</div> <div>4407</div> <div>12</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

EP 10/10/26

10-10-12

(4)

114968

EP 10/10/26

32

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Dart Aerospace Ltd

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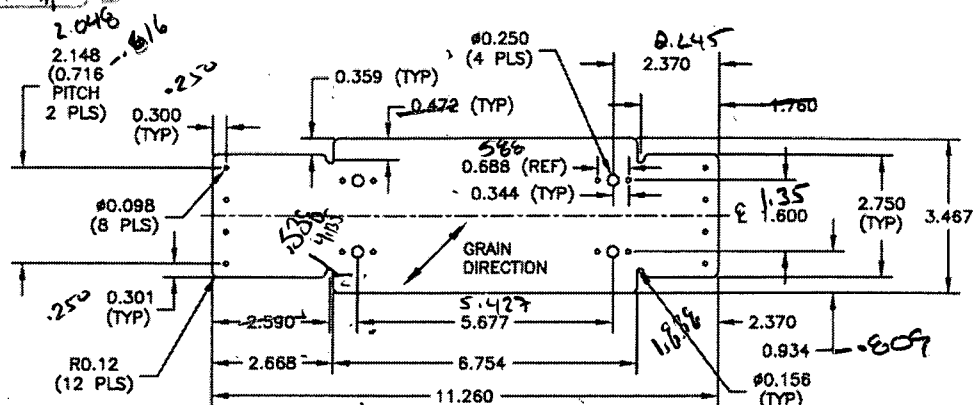
NOTE: Date & initial all entries

SHO200 Y

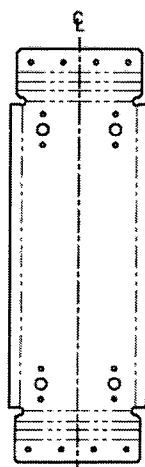
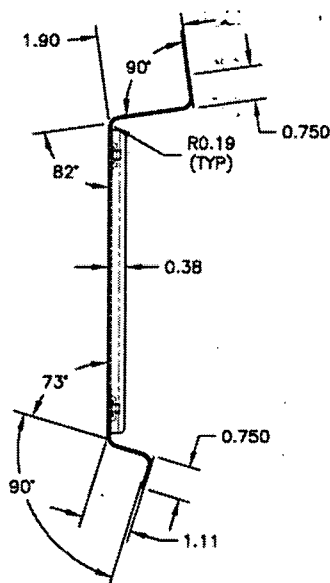
REFUGED

DARTVARIABLE SIZE
WORK ORDERNO. 02822

DESIGN #	DRAWN BY IT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3246	REV. A SHEET 1 OF 1
DATE 04.04.21	TITLE MOUNTING BRACKET	SCALE 1:4	
A	04.04.21	NEW ISSUE	
AI	IT 04.06.16	CHANGE RIVET; ADDED C'SINK	

RELEASED
04.05.07

3.061

D3246-1 FLAT PATTERN**D3246-1 BEND DETAIL****D3246-041 ASSEMBLY**

MS21059-L3
NUT PLATE (1)
MS20470AD3-4 RIVET (2)
(4 PLACES)
INSTALL AFTER
ALODINE
C'SINK $\phi 0.130 \times 100^\circ$
MS20426AD3-3 RIVET (2)

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) 0.050 THICK (REF. DART SPEC. M2024T3S.050)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Dart Aerospace Ltd

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